

Work Order ID 149141

Tuesday, July 19, 2016 2:41:40 PM

149141

Page 1

Item ID: D4634-141

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 7/13/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

JUL 20 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4634	G

100

0.00

100

HandThermo

Memo

0.14

Hand Finishing Thermoforming

Pick Kit

AUG 24 2016

DAS
6
9-89

110

0.00

110

Small Fab

Memo

0.21

Small Fab

Assemble as per Dwg D4634-141

1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe

2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # M135436Expiry Date 03/11/2017

3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer

x1

DAS
07
9-89

16/10/03

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

AGAINST DEPARTMENT/PROCESS

Water Jet ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Supplier ☐

Engineering ☐
Quality ☐
Other ☐

MRB (QS1042) Approval

Completed By ☐

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

Skid-tube ☐
Machining ☐
Thermoforming ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐
Composite ☐

QTY Effective :

Disposition

Description Work Order Deviation

FAULT CATEGORY

Temperature/Cure ☐
Set-up ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Inspection Incomplete/Unqualified ☐
Contamination ☐
Countersink ☐
Cut Too Short ☐
Instructions Incomplete/Unclear ☐
Drill Holes ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set ☐
Mislabeled ☐
Fit/Function ☐
Misaligned/off center ☐

Positioned Wrong ☐
Outside Dimension ☐
Over/Under tolerance ☐
Part Incorrect ☐
Part Lost/Missing ☐
Part Moved ☐
Drawing ☐
Finish ☐
Misread ☐
Turning ☐

Root Cause

Environment ☐
Design ☐
No Re-verification ☐
Operator ☐
Offset/Setup ☐
Supplier ☐

Pressure/Forced ☐
Bending ☐
Centre Not Concentric ☐
Cracks ☐
Crimp/Kink/Ripple/Wave ☐
Cuffs ☐
Machining ☐

Work Order ID 149141

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149141

Page 2

Item ID: D4634-141 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd, Center Ceiling Replacement Panel Assembly
Start Date: 7/13/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/19/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing <i>HA</i> Memo <i>PTO</i> DAS 9 9-89	0.00 0.00							
125 *125* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>①</i>	<i>16-11-02</i>		DAS 9 9-89
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo <i>APP149077</i>	0.00 0.00				DAS 27 9-89			<i>not a pvc</i> DAS 27 9-89

NOV 03 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: <u>149141</u> Part No. <u>D4634-141</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date : _____		Step #: <u>120</u>		QTY Effective : _____		MBB (QSI042) Approval <u>9-89 16-11-02</u>																																																																	
Description Work Order Deviation <u>Remove QCB</u> <u>not applicable.</u>				Disposition 																																																																			
				Completed By <u>16.11.08</u>																																																																			
				Lead hand / Supervisor Approval Verification																																																																			
				QC / QA Coordinator Approval																																																																			
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		OTHER : _____																																																																					

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149141

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N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Start Date: 7/13/2016 **Start Qty:** 1.00 ***1***

Required Date: 7/19/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

140

QC

Memo

0.02

Quality Control

DAS
21
9-89

NOV 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Picklist Print

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Page 1

Work Order ID: 149141

149141

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 7/13/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
 12/11/08 Document release DL VERIFIED BY:JLM
 Dwg Update DL verf: DD
 DL
 DL
 DL
 DL
 IPP Rev B
 IPP Rev C 13/07/09
 IPP Rev D Dwg Update 13/12/23
 IPP REV E Dwg update 14/01/09
 IPP Rev F Dwg. update 14/02/03
 IPP Rev G Dwg. Update 15/01/27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5021-1		Manufactured	No			100	Each	6.0000	1	1			
D5021-1									**				DAS 6 9-89
Foam, Center Panel, Fwd													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF010				6					
				123921				6					
MS20426AD3-4		Purchased	No			100	Each	4,571.000	4	4			
MS20426AD3-4									**				DAS 6 9-89
RIVET													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST312				4571					
				m135127				4571					
				m134294									
MS20426AD4-6		Purchased	No			100	Each	1,987.000	2	2			
MS20426AD4-6									**				DAS 6 9-89
Rivet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				276					
				M128812				16					
				M133234				260					
				ST311				1711					
				M134502				1711					

AUG 24 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>149141</u> Part No. <u>D4634-141</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : <u>Oct 3/16</u>		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval DAS 12 9-89 <u>16/10/3</u>		
Description Work Order Deviation				Disposition				Completed By DAS 12 9-89 <u>16/10/3</u>	
Replace. RIVETS MS20426 AD3-4 WITH CHERRY RIVETS CCR26455-3-03				Use As Is. Acceptable. Ref W/O B149140				Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

Picklist Print

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Work Order ID: 149141

149141

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 7/13/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

MS21059L08

Purchased

No

100

Each

193.0000

2

2

MS21059L 08

Nut

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST300

193

m134634

93

m134943

100

2

AUG 24 2016

D4634-1

Manufactured

No

100

Each

0.0000

1

1

D4634-1

Fwd, Center Ceiling Panel

D4636-5

Manufactured

No

100

Each

29.0000

1

1

D4636-5

Bracket

**

DAS
07
9-89

16/09/29

Location

Loc Qty

Loc Code

ST115

29

129249

29

D4647-5

Manufactured

No

100

Each

13.0000

1

1

D4647-5

Doubler

**

DAS
6
9-89

Location

Loc Qty

Loc Code

MF004

13

125019

5

129252

8

D4664-5

Manufactured

No

100

Each

27.0000

6

6

D4664-5

Spacer

**

DAS
6
9-89

149152

Location

Loc Qty

Loc Code

MF004

27

129261

27

AUG 24 2016

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Work Order ID: 149141

149141

Parent Item: D4634-141

D4634-141

Parent Item Name: Fwd, Center Ceiling Replacement Panel Assembly

Start Date: 7/13/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

D4712-1 Manufactured No

100 Each 0.0000 1 1

D4712-1

125020

DAS
6
9-89

Bracket

D4732-15 Manufactured No

100 Each 1.0000 1 1

D4732-15

Label

Location

Loc Qty

Loc Code

MF005

1

123207

1

D4732-19 Manufactured No

100 Each 13.0000 1 1

D4732-19

Label

Location

Loc Qty

Loc Code

MF005

13

120070

1

123209

12

MPNY-750S-9-C Purchased No

100 Each 851.0000 7 7

MPNY-750S-9-C

Mounting Pad

Location

Loc Qty

Loc Code

ST583

851

M130423

851

DAS
6
9-89

AUG 24 2016

DQA: _____ Date: _____

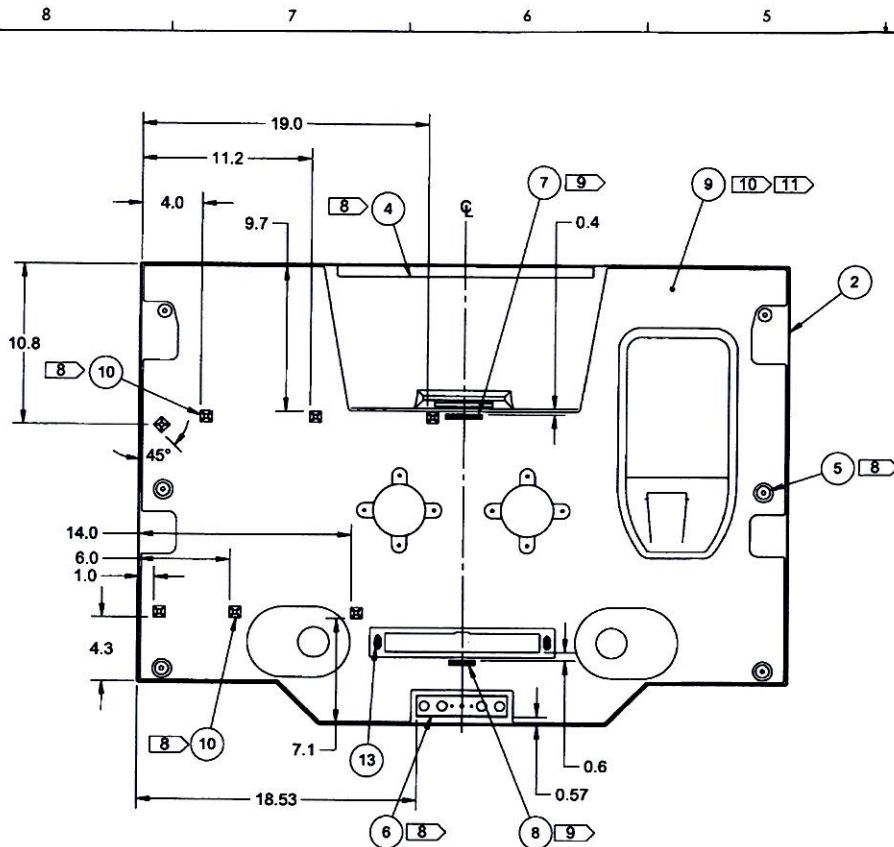


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

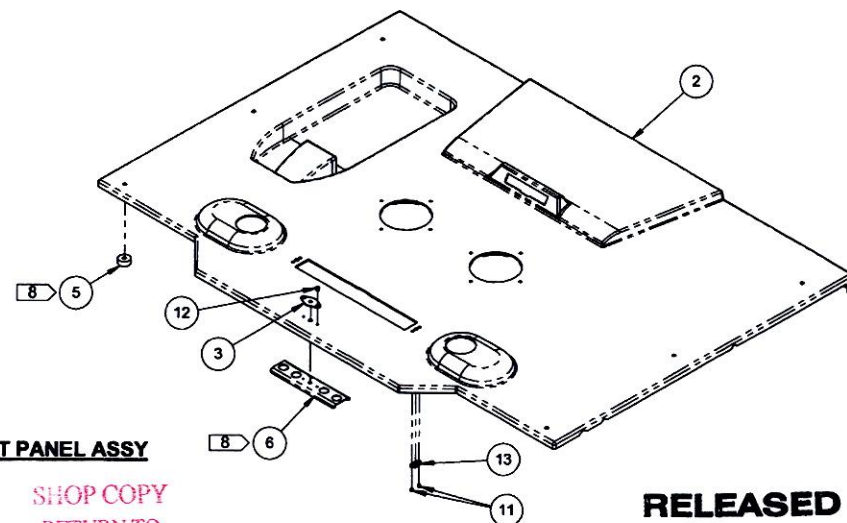


D4634-141 FWD, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4664-5, D4712-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-1 FOAM ON D4634-1

ITEM	QTY	P/N	DESCRIPTION
1	X	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-1	FWD, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-5	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-15	LABEL
8	1	D4732-19	LABEL
9	1	D5021-1	FOAM, CENTER PANEL, FWD
10	7	MPNY-750S-9-C	MOUNTING PAD
11	4	MS20426AD3-(4)	RIVET, SOLID, CSK
12	2	MS20426AD4-(6)	RIVET, SOLID, CSK
13	2	MS21059L08	NUT PLATE



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NO. 149141 MLS
160720

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4634	REV. G
MFG. APPR.	DL	SHEET 7 OF 17	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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